

Date: Monday, 12/01/2009 2:36:47 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WINDOW FRAME
Job Number :	44652		
Estimate Number :	13068		
P.O. Number :		Part Number :	D35433
This Issue :	12/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3543 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	35723	Drawing Revision :	B
	Type :	Material :	
	SMALL /MED FAB	Due Date :	02/02/2009
Written By :		Qty:	6
Checked & Approved By :	JLD 09.01.13	Um:	Each
Comment :	Est Rev:A New Issue 07-11-14 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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109463x3



Comment: Qty.: 2.6606 sf(s)/Unit Total : 15.9636 sf(s)

Material: 2024T3 sheet 0.063" thick.

Batch 110980 IR 9-4-5

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3543

Dwg Rev: B IR 9-4-5

Prog Rev: B

8

2-Deburr if necessary IR 9-4-5

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IR 9-4-5



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

808/04/06 (25)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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(18)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

UNDY SL

09/04/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:36:48 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW FRAME

Job Number: 44652

Part Number: D35433

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(8)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 09/04/08

7.0

PACKAGING 1

PACKAGING RESOURCE #1



(8k)

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: 217 9146

sp

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

09/04/09

Job Completion



MF 09-04-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D3543	REV. B SHEET 1 OF 2
DATE 06.11.24		TITLE HINGE DOOR PUSH-OUT WINDOW	SCALE 1:4
A	06.08.01	NEW ISSUE	
B	06.11.24	REMOVE D3568-1 PLACARD; D3543-041 ASS'Y NOT REQUIRED ANYMORE	

D3543-1 HINGE PANEL DOOR PUSH-OUT WINDOW

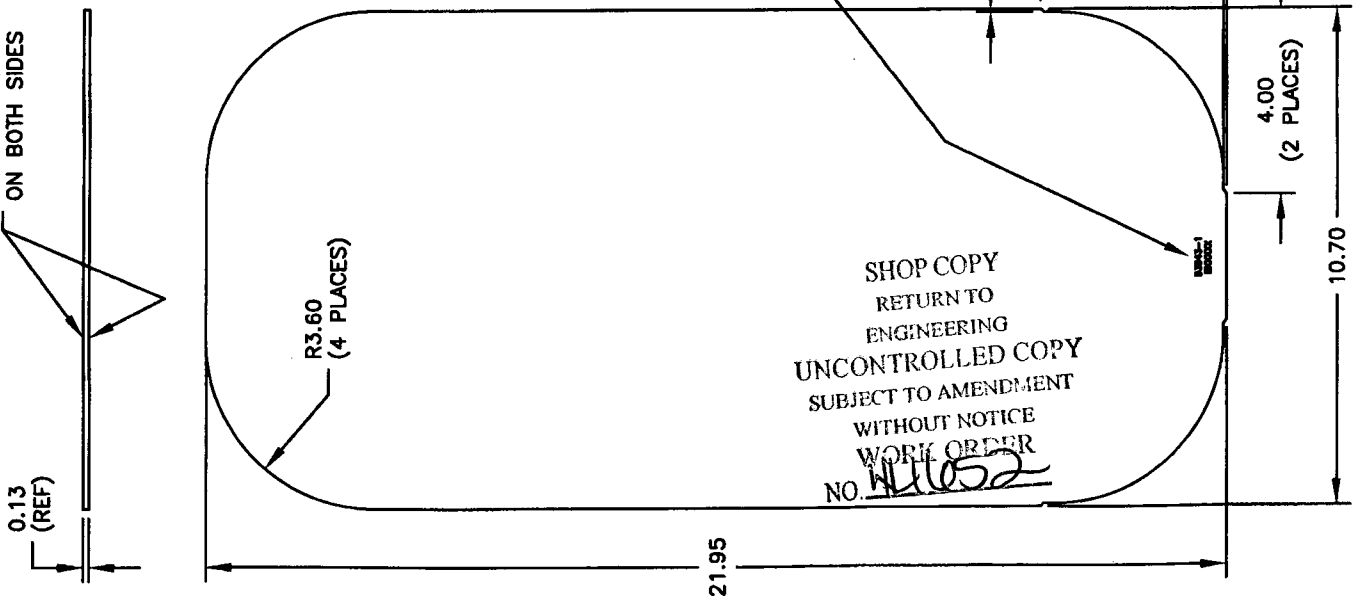
NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS "G" CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125" THICK (REF DART SPEC. M-ACRYLIC-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.12.12 *H*

3M MASKING FILM PR-N3213
ON BOTH SIDES



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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3543	REV. B SHEET 2 OF 2
DATE 06.11.24		TITLE HINGE DOOR PUSH-OUT WINDOW	SCALE 1:4

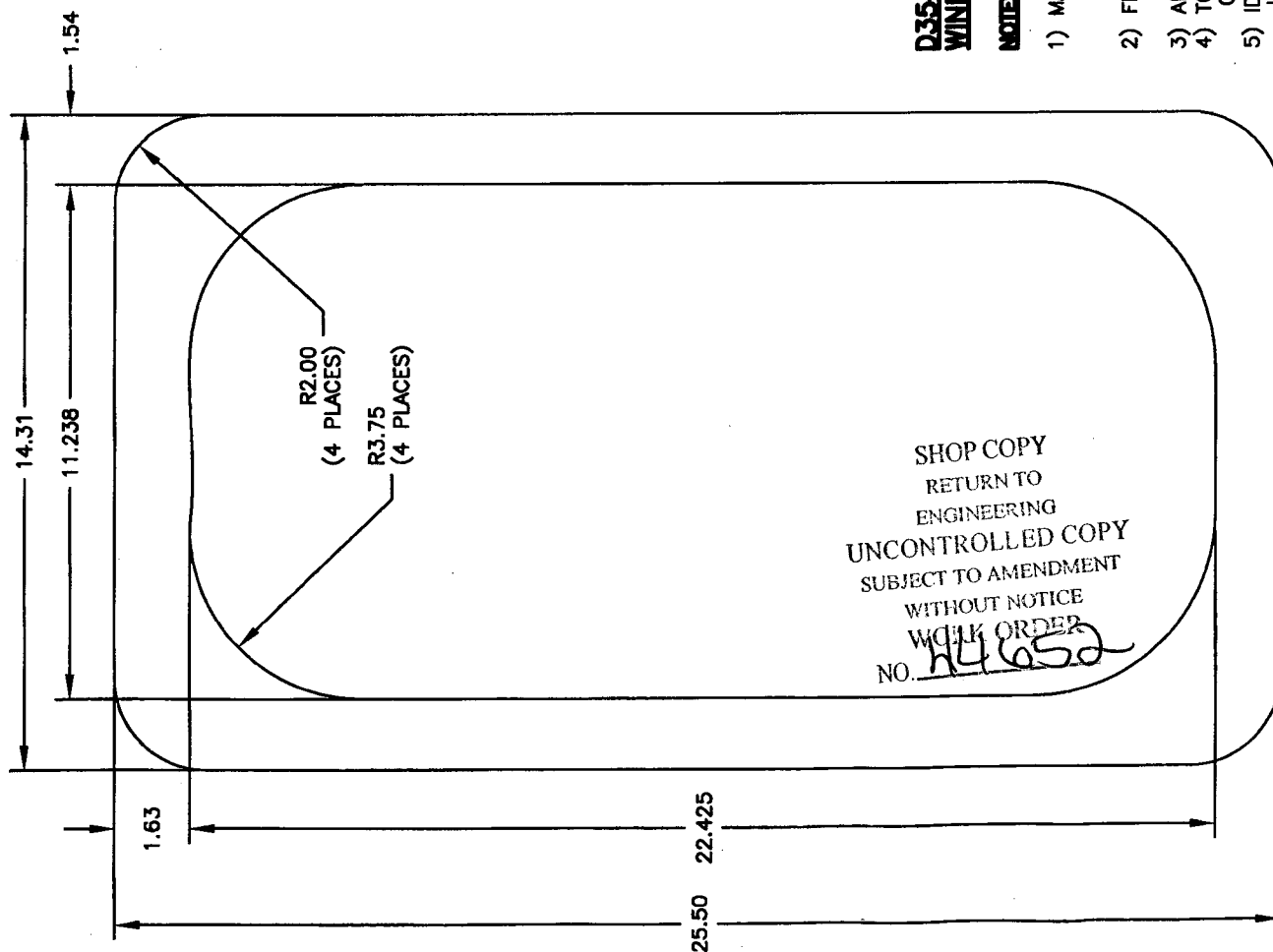
RELEASED

06.12.12

D3543-3 HINGE DOOR PUSH-OUT WINDOW FRAME

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK ALUMINUM SHEET (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) IDENTIFY WITH DART P/N D3543-3 & B/N USING FINE POINT PERMANENT MARKER



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